Work Order ID 59151

Thursday, May 27, 2010 9:21:29 AM

Item ID: D3793-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Wearshoe

Start Date: 5/27/2010 **Start Qty:** 16.00 **Cust Item ID:**

Required Date: 6/4/2010 **Req'd Qty:** 16.00 **Customer:**

Reference:

Approvals: **Process Plan:** RL **Date:** 10-5-27 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D3793	Revision Nbr: Rev A								
100	FLOW WATER JET	0.00							
Waterjet									
	Memo	0.00				HB 10-5-31			
FLOW CNC Waterjet	1-Cut as per Dwg D3793 ☐Dwg Rev: A ☐Prog Rev: A ☐2-								
304. 040	Deburr if necessary					16			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC									
	Memo	0.00				HB 10-5-31			
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC									
	Memo	0.00				16			
Quality Control									

5/10/05/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 59151

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Item ID: D3793-1 **Accept** **Setup Start**

Revision ID:

Item Name: Wearshoe **Stop**

Start Date: 5/27/2010 **Start Qty:** 16.00 **Cust Item ID:**

Required Date: 6/4/2010 **Req'd Qty:** 16.00 **Customer:**

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Brake NC	NC BRAKE								
Brake NC	**Memo**	0.00			SD 10/06/07	16			
	1-Deburr if necessary□2-Form on Brake as per Dwg D3793 using Jigs □3-Form Joggle on brake using Jig as per Dwg D3793								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00			SD 10/06/07	(16)			
Quality Control									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	M112588				21 JH 10/06/07	16	0		
Powder Coating	**Memo**	0.00							
	START TIME: 8:30AM □OVEN TEMPERATURE: 400°F □FINISH TIME: 320°F								

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 59151

Thursday, May 27, 2010 9:21:29 AM

Item ID: D3793-1
Revision ID:
Item Name: Wearshoe
Start Date: 5/27/2010 **Start Qty:** 16.00
Required Date: 6/4/2010 **Req'd Qty:** 16.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:**_____ **Tooling:** _____ **Date:**_____
QC: _____ **Date:**_____ **SPC (Y/N):** _____ **Date:**_____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				16	BR 10-6-3		
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location:_____	0.00				16			
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00				16	10/06/04		
QC	**Memo**	0.00							
Quality Control									

RL 10-6-03

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 27, 2010 9:21:33 AM

Work Order ID: 59151

Parent Item: D3793-1

Parent Item Name: Wearshoe

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Start Date: 5/27/2010 **Required Date:** 6/4/2010

Start Qty: 16.00 **Required Qty:** 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	172.9926	0.5902	9.940211	10.	5-31	

304/316 .040 Sheet

Location		Loc Qty	Loc Code
MAT		168.7278	
	114574	168.7278	
MAT20		4.2648	
	112885	2.7475	
	113062	1.5173	

114574

(16)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59151
Description: Wearshoe	Part Number:	D3793-1
Inspection Dwg: D3793 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.197	3			
0.300 x 0.300	+/-0.010	.304X.305	4			
1.885	+/-0.010	1.890	5			
2.000	+/-0.010	2.000	6			
5.00	+/-0.030	5.00	9			
8.00	+/-0.030	8.00	8			
14.00	+/-0.030	14.00	9			
20.00	+/-0.030	20.00	7			
14.066	+/-0.010	14.066	10			
18.983	+/-0.010	18.983	2			
23.900	+/-0.010	23.900	2			
27.400	+/-0.010	27.400	5			
29.400	+/-0.010	29.400	8			
32.900	+/-0.010	32.900	5			
0.040	+/-0.010	.037	4			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	10-5-31	Date:	10/05/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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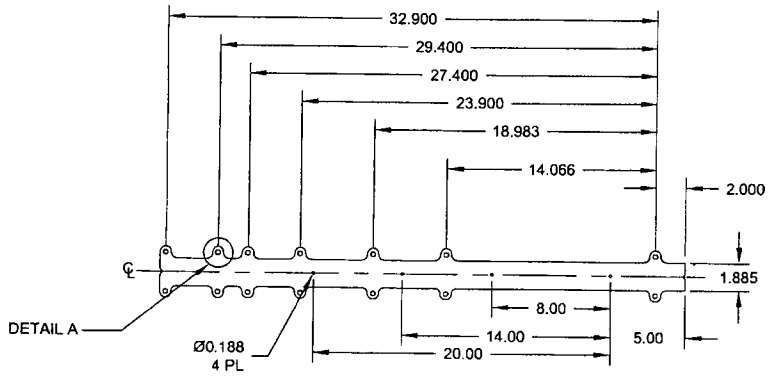
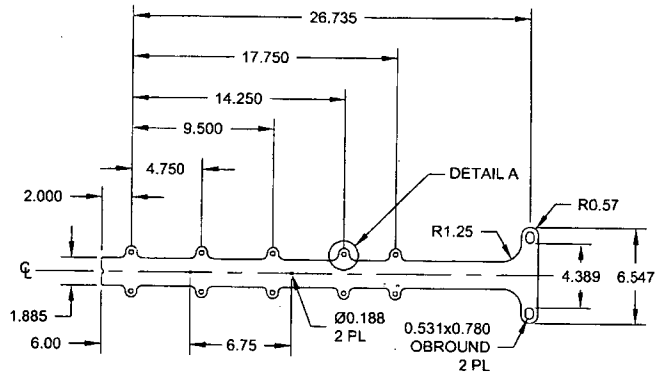
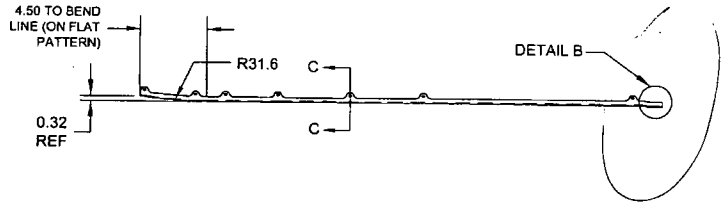
NOTE: Date & initial all entries



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)

D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59151
5-10-27

RELEASED
08.05.23 PH

NOTES:
1) MATERIAL: AISI 304/316 SS SHEET SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENIFTY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	PH	08.05.14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	08.05.14		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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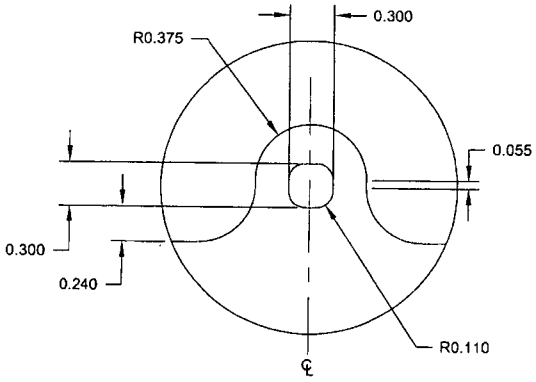
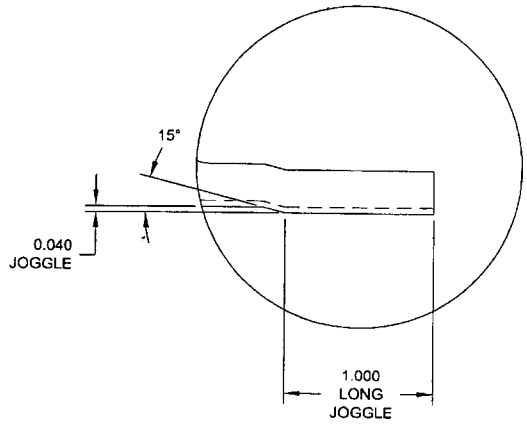
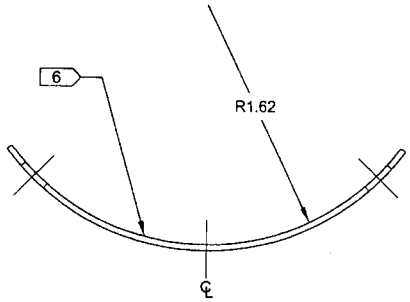


DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

RELEASED
08.05.23 WD

W/O 39151

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	08.05.14		

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